

Date: Tuesday, 15/07/2008 9:15:39 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BEARING ASSEMBLY
Job Number :	40496		
Estimate Number :	11136		
P.O. Number :		Part Number :	D3183045
This Issue :	15/07/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3183 REV C1
First Issue :	/ /	Project Number :	N/A
Previous Run :	40159	Drawing Revision :	C1
Written By :		Material :	
Checked & Approved By :	<u>JULIO 08.15.08</u>	Due Date :	30/07/2008
Comment :	Est A04.02.18 New issue KJ/DS	Qty:	46 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELRLNR1000	Delrin Round Bar 1"
-----	--------------	---------------------



Comment: Qty.: 0.0350 f(s)/Unit Total: 1.3986 f(s)

Delrin Round Bar 1"

Material: ~~01.00~~ Delrin Rod 01.250 DELRIN ROD

(M-DELRIN-R1.000)

Identify as D3183-9

Batch: M107758

J.F. 08/07/26

(46)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

Turn D3183-9 Cap as per Folio FA388

Deburr

J.F. 08/07/26

(46)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/07/26

(46)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

20 08/07/26

5.0	D31835	Bearing
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3183-5

Bearing

40181

JS 08/07/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/07/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:15:39 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING ASSEMBLY

Job Number: 40496

Part Number: D3183045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183.

08/07/28 (46)

7.0

QC5

INSPECT WORK TO CURRENT STEP



counts

Comment: INSPECT WORK TO CURRENT STEP

08/07/28 (46)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Emilie 08/07/28 (46)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(46)

Comment: FINAL INSPECTION/W/O RELEASE

*08/07/28
mf 08-07-28*

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

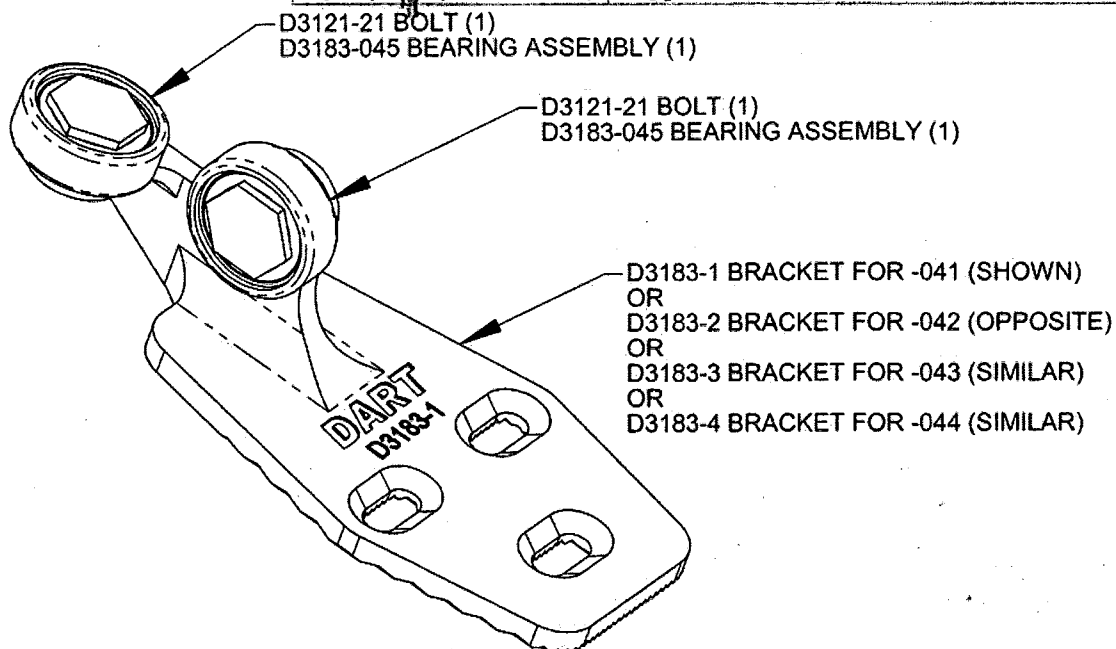
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

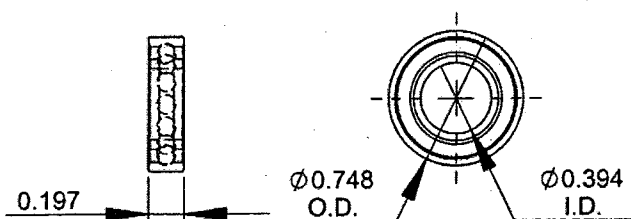


DESIGN #	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1
A.	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
C1	# 04.11.09	0.830 WAS 0.850	

RELEASED
04.03.01



D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



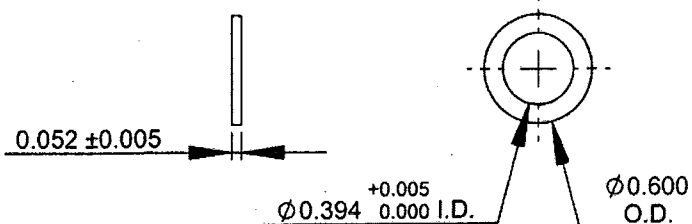
D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER
40496

D3183-7 WASHER

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES



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NO. 40474

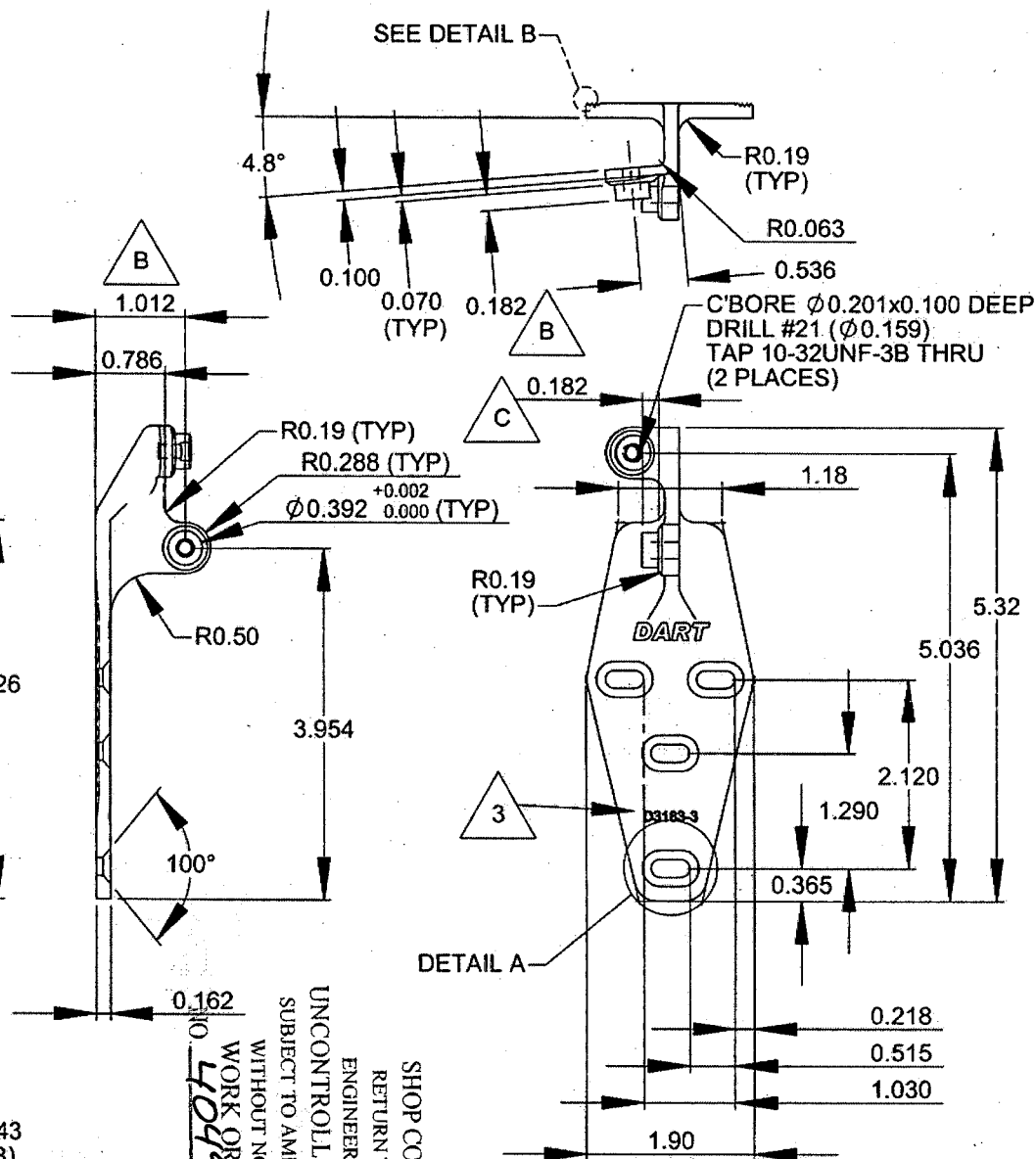
04-0301 #



DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN BY	<i>[Signature]</i>	DRAWING NO.	REV. C
CHECKED	<i>[Signature]</i>	D3183	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE	04.02.17	BRACKET ASSEMBLY	1:2



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CHECKED	APPROVED	DRAWING NO. D3183
DATE 04.02.17	TITLE BRACKET ASSEMBLY	REV. C SHEET 3 OF 4
	SCALE 1:2	



D3183-3 BRACKET SHOWN
(REPLACES BELL P/N 412-030-304-105)
D3183-4 BRACKET OPPOSITE
(REPLACES BELL P/N 412-030-304-106)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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NO 40490

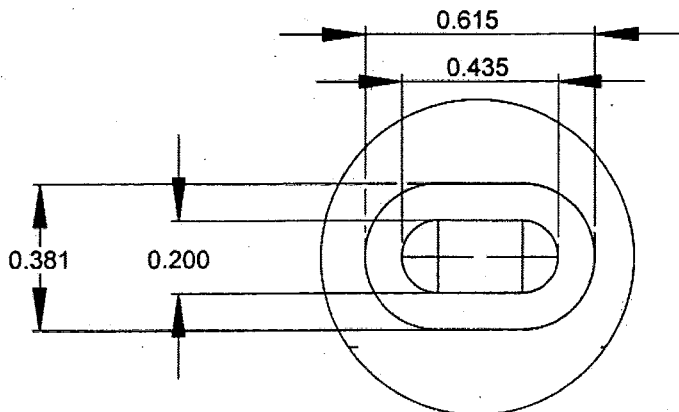
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24-03-01

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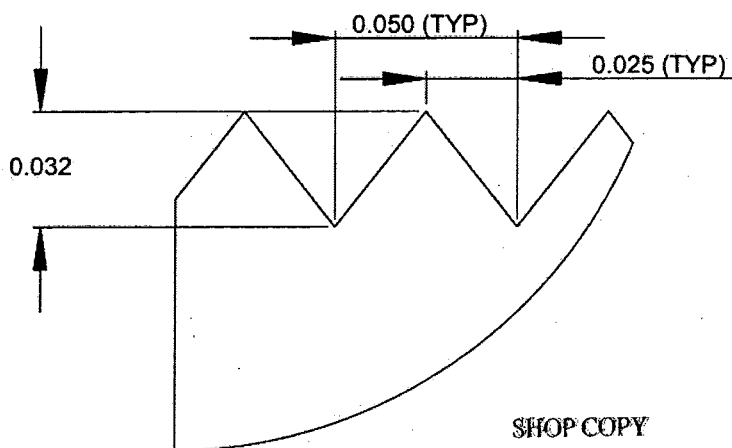


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1



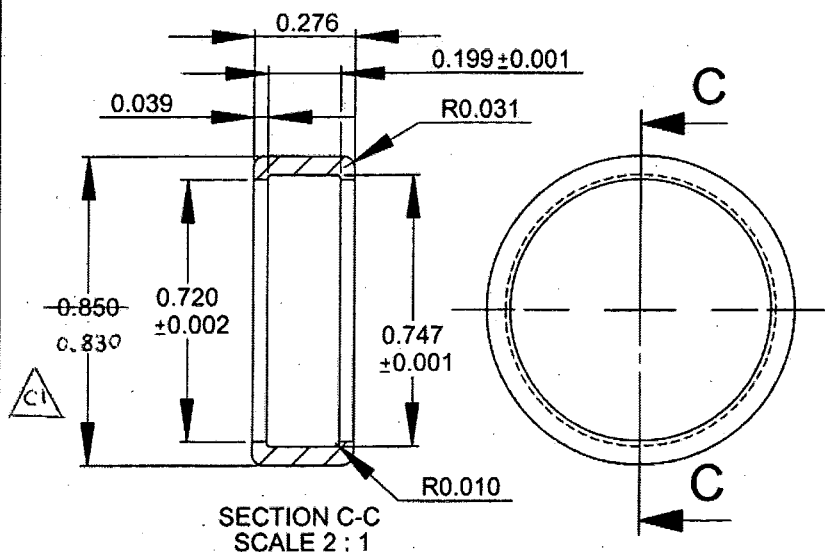
DETAIL A (2 : 1)

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04-03-01 *[Signature]*



DETAIL B (20 : 1)

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WORK ORDER
NO. *40496*



D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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